

FIG. 1

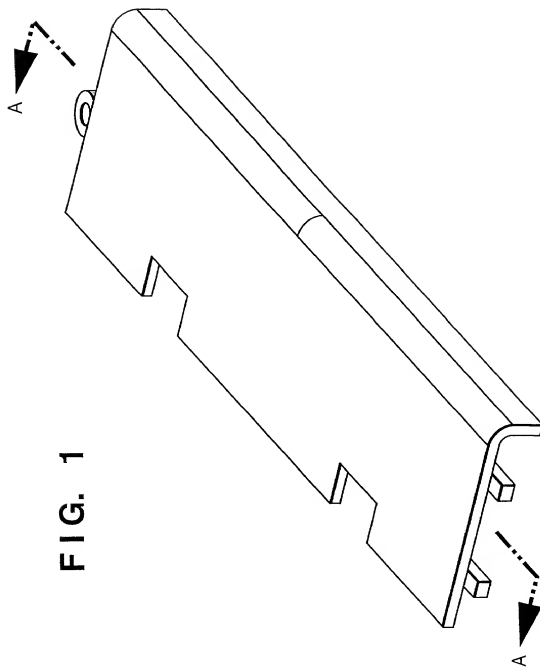


FIG. 2

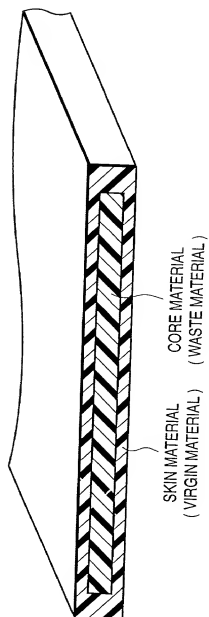


FIG. 3

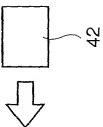
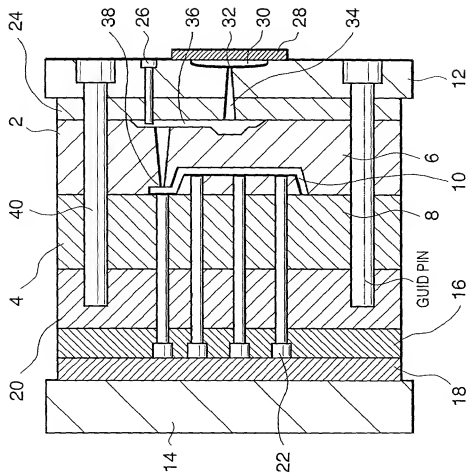


FIG. 4

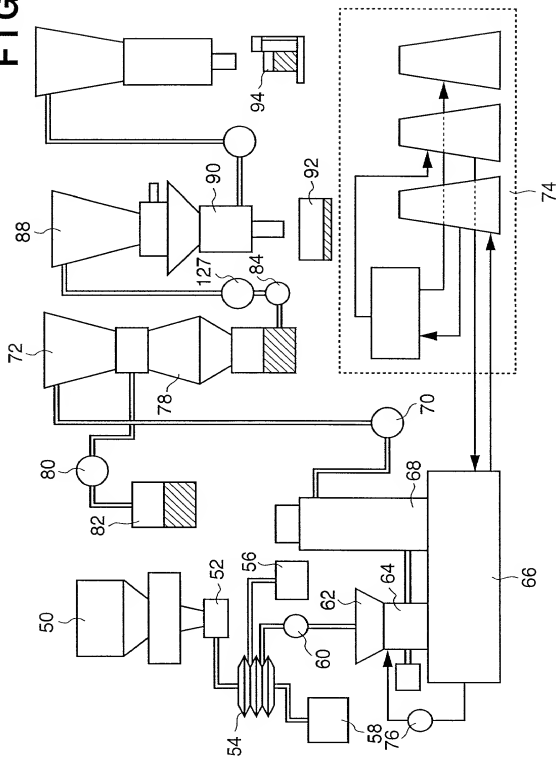


FIG. 5

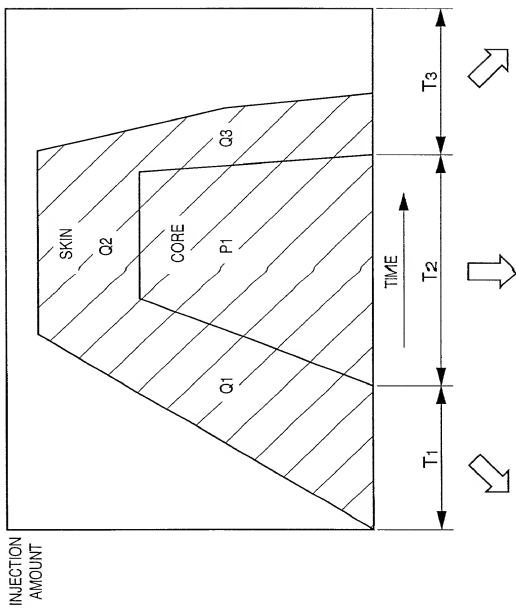
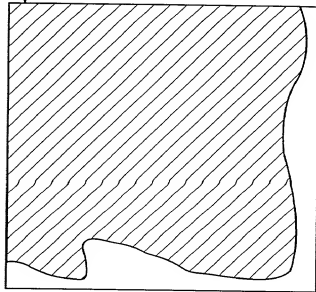


FIG. 7GATE
POSITION

CORE LAYER RESIN FILLED PORTION



SKIN LAYER RESIN ALONE

FIRST EMBODIMENT

09897044.070301

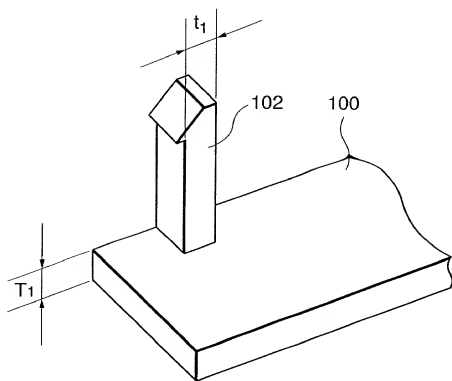
FIG. 8

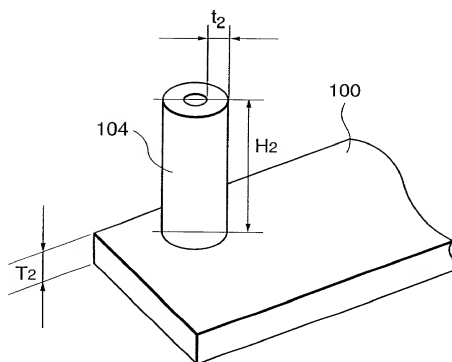
FIG. 9

FIG. 10

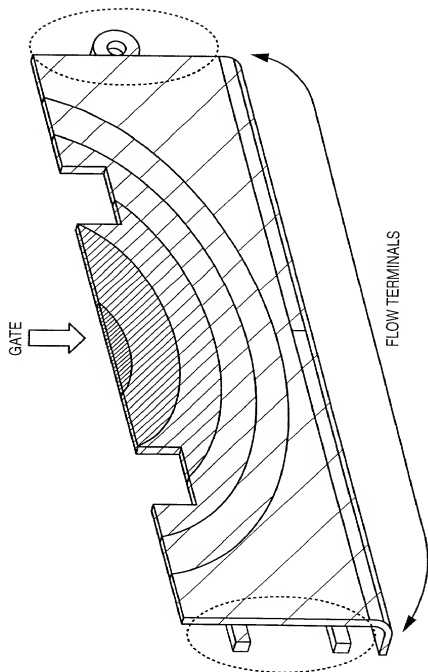


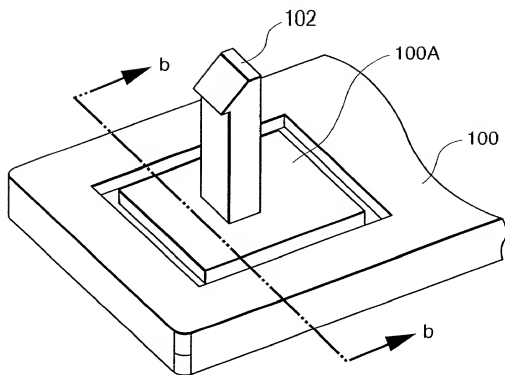
FIG. 11

FIG. 12

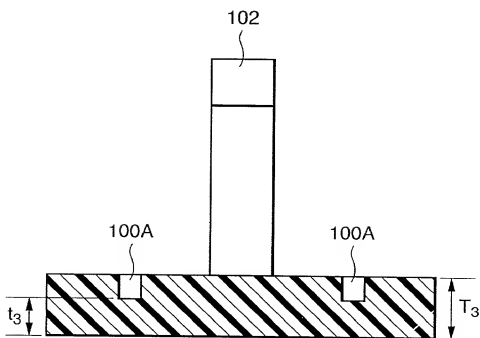


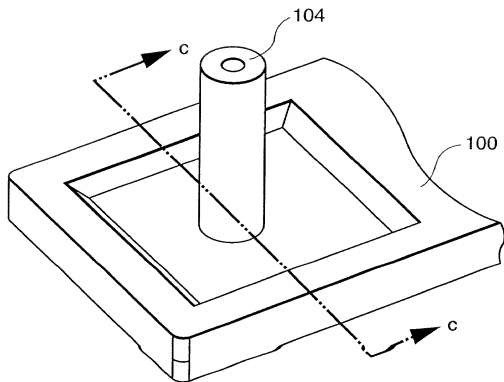
FIG. 13

FIG. 14

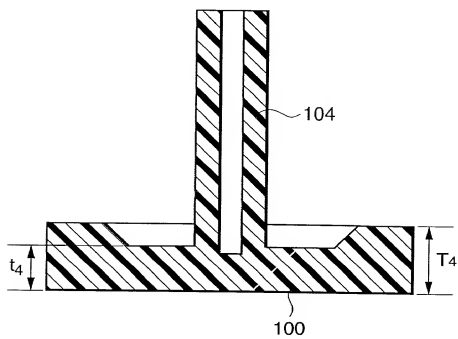


FIG. 15